

DART AEROSPACE LTD		Work Order:	24354-2
Description:		Part Number:	D2803/04 PS D2804-1/-2
Dwg:	Re-machine per Rev. B	Qty:	
			Page of

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
1		Re-machine D2804 brackets AS per Dwg D2804 Rev B: D2804-1 B14241 Qty 2 D2804-2 B14242 Qty 10	SA	06.01.15	2 9 9
2	QC2	Inspect parts AS they come off of CNC	SA	06.01.15	9
3	QC7	second inspection check	SG	06.01.16	9/2
4	FP	Touch-up Abalone AS required	CL	06.01.16	7/2
5	QC5	Inspect work		06.03.02	-1x2 -2x3
6	BT	Identify and stock with batch # indicated on W/O.			
7	AC	cost			
8	DC/QC21	close W/O			
4b	GA	For 2 parts: Press D2805-1 into arm per dwg D2803/D2804 D2804 1 B B14241 D2805-1 B 23628 B23628	SD	06/01/16	2
4c	QC	Inspect Level 5	U	06.01.16	2
4d	FP	Powder coat Gloss white	M	06.01.17	
4e	QC3	Inspect Powder coat			
4f	GA	Press D2809 B B22529 (1) B22545 into arm per dwg D2804	SA	05.03.01	5

Rev	Date	Change	Revised By	Approved

4g GA follow attached info from step 7

U 06/03/24

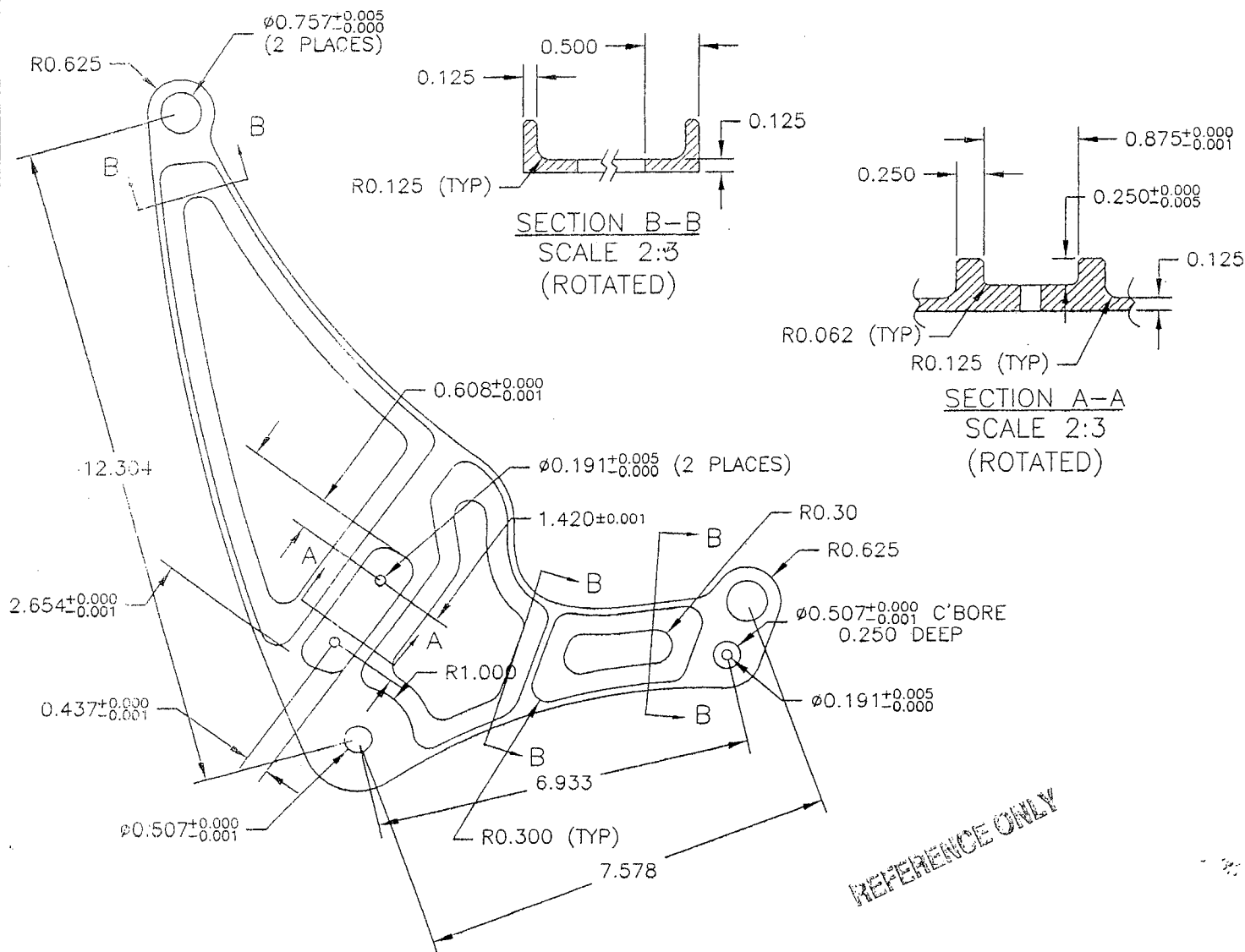
CONTROLLED COPY



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804 REV. B SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED

05-03-11 *[Signature]*



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Monday, 11/21/2005 3:33:33 PM
Linda Lacelle

Process Sheet

Order Number	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2804
Estimate Number	: 24354	Part Number	: D28031
P.O. Number	: 10804	Drawing Number	: Z_CUSTOM
This Issue	: 11/21/2005 S.O. No. :	Project Number	:
Prsht Rev.	: NC	Drawing Revision	:
First Issue	: / / Type :	Material	:
Previous Run	: 00015	Due Date	: 11/28/2005 Qty: 1 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
REMACHINE PER REV. B D2803/D2804

SD 06.01.15

2.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 06.01.15

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BG 06.01.16

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
BAG & TAG

2XD2804-043
3XD2804-044

ST 1161

C 206/03/27 (5)

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

D 06/03/28 (5)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-15	1	part pressed in D2804 hit by end mill.		Scrap and destroy	SA 06-01-15	2 06-01-16		2 06-01-16
06-01-25	4	1x D2804-2 bracket left in Alocline for since 06-01-16, and had been dipped in acid with. D2805-2 already pressed in. Part burned by alocline.	PB 06-01-25	Scrap and destroy. ensure employee checks Qty of parts after Abolining	2 06-01-25	2 06-01-25	PB 06-01-25	2 06-01-25

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Bracket Assembly		Part Number:	D2804-041
Dwg: D2804 Rev. B		Qty:	
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Dwg not required																							
2	GA	Press D2805-1 into arm as per Dwg D2804 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2804-1</td><td>Bracket</td><td></td></tr><tr><td>1</td><td>D2805-1</td><td>Stop</td><td></td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td></td></tr></table>	Qty	Part Number	Description	Batch	1	D2804-1	Bracket		1	D2805-1	Stop		1	D2809	Bushing								
Qty	Part Number	Description	Batch																						
1	D2804-1	Bracket																							
1	D2805-1	Stop																							
1	D2809	Bushing																							
3	QC5	Inspect work to Step 2																							
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3																							
5	QC3	Inspect Powder Coat																							
6	GA	Press D2809 into arm as per Dwg D2804																							
7	GA	Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN3C16A</td><td>Bolt</td><td>117944</td></tr><tr><td>2</td><td>MS21043-3</td><td>Nut</td><td>114099</td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer</td><td>117944</td></tr><tr><td>A/R</td><td>LPS-3</td><td>Corrosion Spray</td><td></td></tr></table>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt	117944	2	MS21043-3	Nut	114099	4	NAS1515H3	Washer	117944	A/R	LPS-3	Corrosion Spray		SAD	060121	18
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt	117944																						
2	MS21043-3	Nut	114099																						
4	NAS1515H3	Washer	117944																						
A/R	LPS-3	Corrosion Spray																							
8	GA	Assemble as per Dwg D2804.																							
9	QC5	Inspect work to Step 8																							
10	ST	Identify and Stock																							
11	AC	Cost / part: _____																							
12	DC	Close W/O Inspect Level 21																							

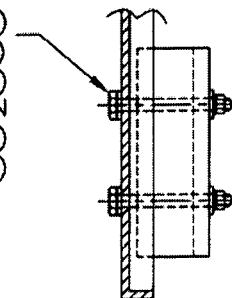
Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	
F	05.03.30	MS21043-3 was MS21042L3	KJ/JLM	

REFERENCE ONLY



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

SECTION C-C
SCALE 1:3
(ROTATED)

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

RELEASED

05-03-11

D2804-041/-043 BRACKET ASS'Y (SHOWN),
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

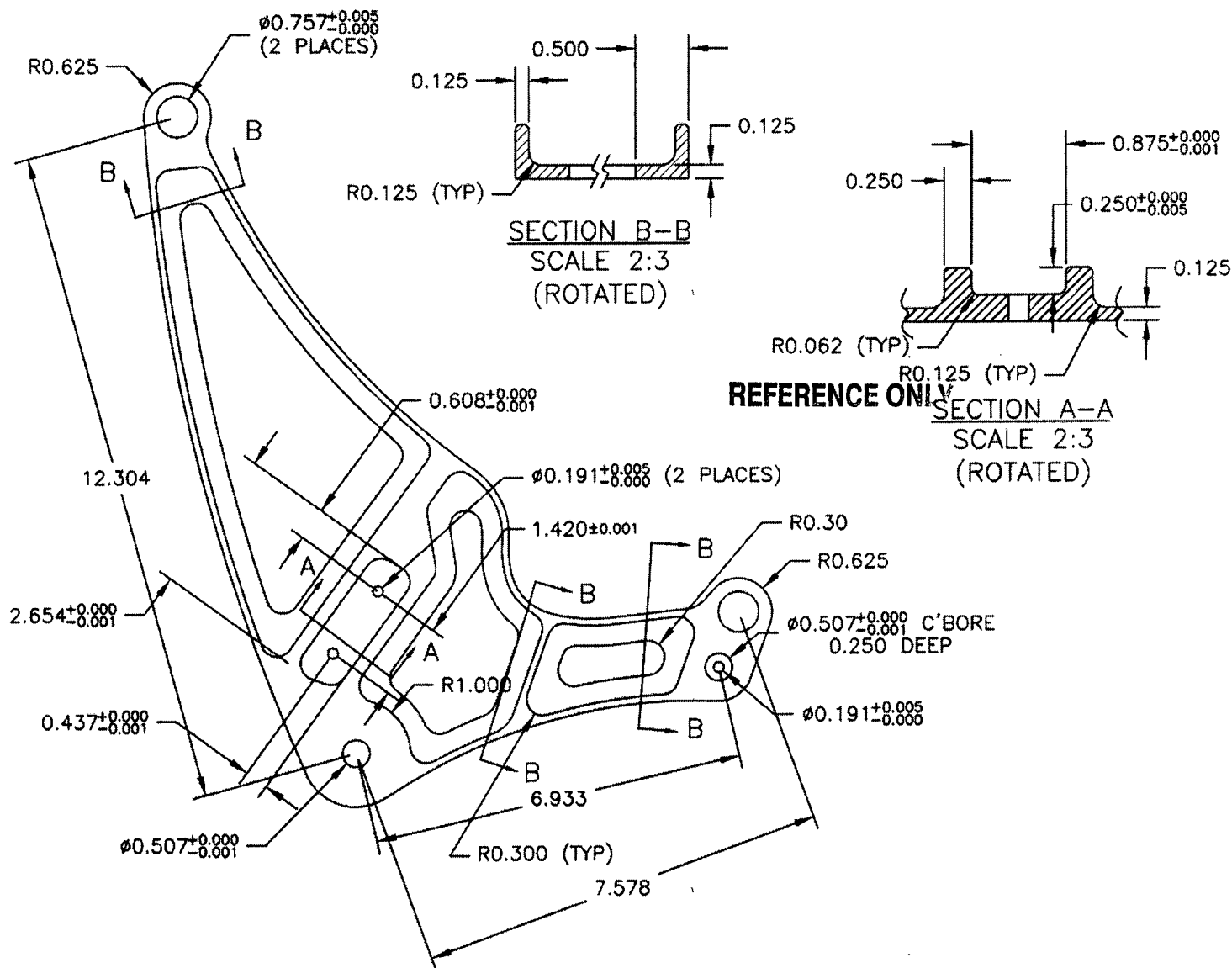
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2804	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 155 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05.03.11



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

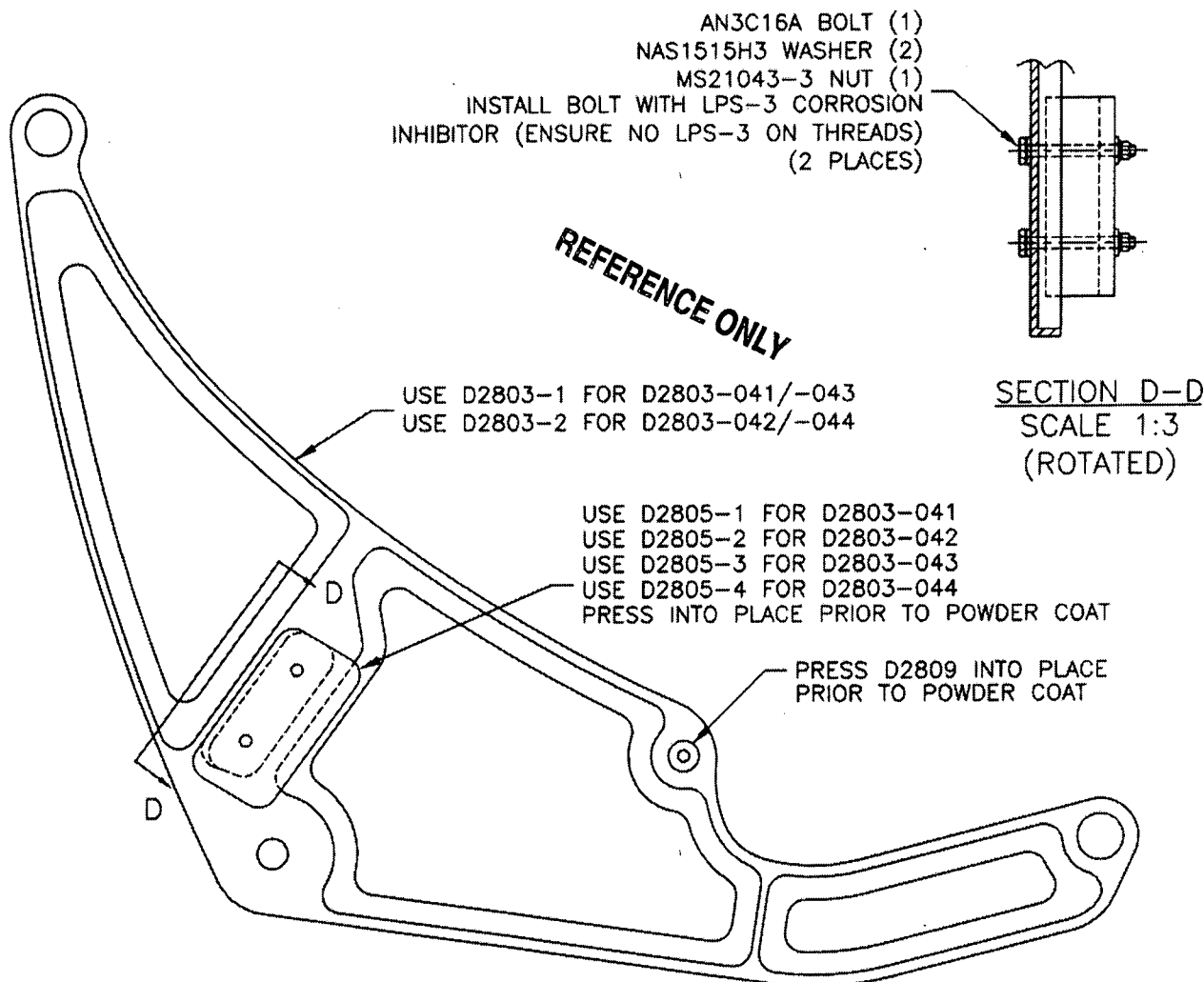
- 1) MACHINE PER DRAWING FILE "D2804.SLDPRF"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03-11 *[Signature]*



D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

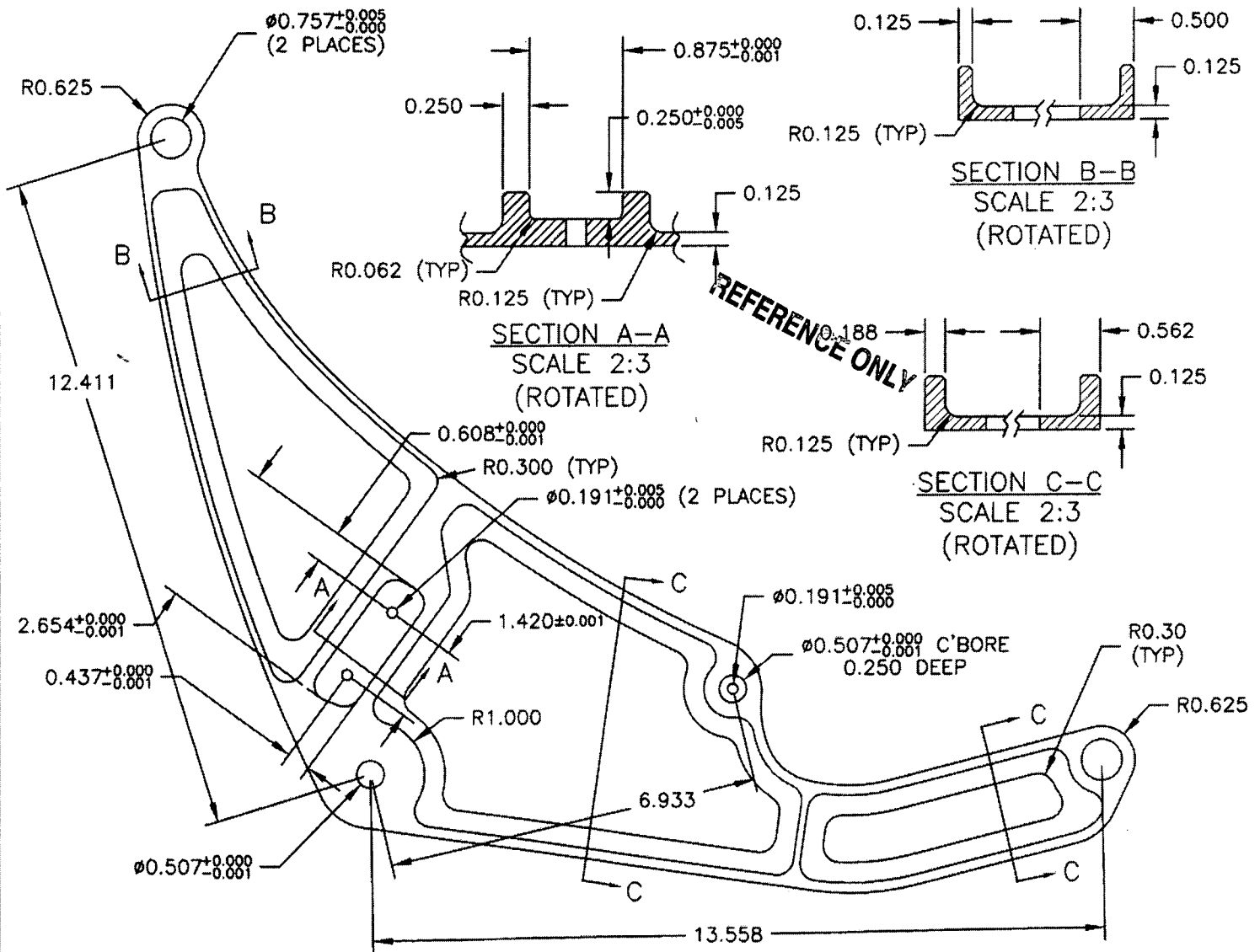

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED05.03.11 **D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.